

Work Order ID 71478

Tuesday, July 05, 2011 7:28:36 AM



Page 1

Item ID: D130-780-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Spacepod, RH

Start Date: 7/5/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/15/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

IIN-D130-780

B

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels per PPP D130-780-042 CHG 003

8/11/11

df des CL 11-7-11

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

RT 11-07-06

Work Order ID 71478

Tuesday, July 05, 2011 7:28:36 AM



Page 2

Item ID: D130-780-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Spacepod, RH

Start Date: 7/5/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/15/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

0.00



Small Fab

Memo

0.00

Small Fab

1- Assemble as per dwg D3188,
2- use door to transfer drill hole location.
3- Remove foam core as per IIN- D350-600 figure 17a. Fill holes with Hysol
934NA with 10% milled fiber
A/R Hysol Batch: 117700
EXP: 12-05-13
A/R milled fibers Batch: 100859

25 11-07-06

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

11 09 07 05

133

0.00



SprayPaint

Memo

0.00

Spray Painting

1- Prime as per Qsi 005
A/R primer Batch: 116563
A/R activator batch: 116563

25 11 07 07

Work Order ID 71478

Tuesday, July 05, 2011 7:28:37 AM



Page 3

Item ID: D130-780-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Spacepod, RH

Start Date: 7/5/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/15/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

135	QC14- Inspect Spray Paint	0.00							
-----	---------------------------	------	--	--	--	--	--	--	--



QC	Memo	0.00							
----	------	------	--	--	--	--	--	--	--

Quality Control

MA 11 07 07 07

137		0.00							
-----	--	------	--	--	--	--	--	--	--



Small Fab	Memo	0.00							
-----------	------	------	--	--	--	--	--	--	--

Small Fab	1- Install hardware to spacepod ensure proper fit								
-----------	---	--	--	--	--	--	--	--	--

BT 11-07-07

138	QC5- Inspect part completeness to step on W/O	0.00							
-----	---	------	--	--	--	--	--	--	--



QC	Memo	0.00							
----	------	------	--	--	--	--	--	--	--

Quality Control

MA 11 07 07 07

Work Order ID 71478

Tuesday, July 05, 2011 7:28:37 AM



Page 4

Item ID: D130-780-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Spacepod, RH

Start Date: 7/5/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/15/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140



HandFinish

Wing Walk as per dwg QSI005 4.4 Batch 117863

0.00

Memo

0.00

Hand Finishing

TOP SURFACE OF POD

11-07-07

150



QC

QC3- Inspect Part Finish

0.00

Memo

0.00

Quality Control

160



Packaging

Pick Kit

0.00

Memo

0.00

Packaging

11/7/11

Work Order ID 71478

Tuesday, July 05, 2011 7:28:37 AM

Page 5

Item ID: D130-780-042

Accept

Setup Start

Revision ID:

Stop

Item Name: Spacepod, RH

Start Date: 7/5/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 7/15/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

180

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D130-780-042

Location:

PPP Rev:

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/14
MF
11-07-14

Picklist Print

Tuesday, July 05, 2011 7:28:32 AM

Page 1

Work Order ID: 71478

Parent Item: D130-780-042

Parent Item Name: Spacepod, RH



Start Date: 7/5/2011

Required Date: 7/15/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 09-02-03 new issue DD verified by:JLM IPP Rev:B
10.03.24 revise process and parts DD verified by:EC IPP Rev:C remove D3188-
2m add D3188-6 DD 10.04.07 verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN526C832R24 screw		Purchased	No			160	Each	49.0000	4	4			
				<u>Location</u>				<u>Loc Qty</u>					
				ST327				49					
					116556			49					
D2179 Doubler		Manufactured	No			110	Each	33.0000	2	2			
				<u>Location</u>				<u>Loc Qty</u>					
				ST007				33					
					35432			33					
D3188-6 Spacepod Body		Manufactured	No			110	Each	0.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>					
					66599								
D3815-5 Packer		Manufactured	No			160	Each	19.0000	3	3			
				<u>Location</u>				<u>Loc Qty</u>					
				ST087				19					
					56523			11					
					61318			8					

85 11-07-09

x4
2

85 11-07-06

x2
1

85 11-07-09

11/7/11

3

Picklist Print

Tuesday, July 05, 2011 7:28:32 AM

Page 2

Work Order ID: 71478

Parent Item: D130-780-042

Parent Item Name: Spacepod, RH

Start Date: 7/5/2011

Required Date: 7/15/2011

Start Qty: 1.00

Required Qty: 1.00

MS21059L3

Purchased

No

160

Each

6.0000

10

10



Nut Plate

Location

Loc Qty

Loc Code

ST302

6

116706

6

MS24694-S54

Purchased

No

160

Each

166.0000

6

6



Screw

Location

Loc Qty

Loc Code

ST289

116

117460

16

118078

100

ST289A

50

117677

50

D130-780-044

Manufactured

No

110

Each

0.0000

1

1



Spacepod Door Assembly, RH

AKS4-1032-130

Purchased

No

110

Each

0.0000

28

28



Inserts

D2237

Manufactured

No

110

Each

58.0000

2

2



Striker Plate

Location

Loc Qty

Loc Code

ST009

58

66139

20

70558

38

Tuesday, July 05, 2011 7:28:32 AM

Shop Packet Print

Page 2

Picklist Print

Tuesday, July 05, 2011 7:28:32 AM

Page 3

Work Order ID: 71478

Parent Item: D130-780-042

Parent Item Name: Spacepod, RH

Start Date: 7/5/2011

Required Date: 7/15/2011

Start Qty: 1.00

Required Qty: 1.00

MS20426AD4-5

Purchased

No

110

Each

5,572.000

4

4



Rivet

Location

Loc Qty

Loc Code

MEZZ

289

6733

289

ST317

5283

6874

5283

D3538-I

Manufactured

No

110

Each

9.0000

2

2



Hinge Bracket

Location

Loc Qty

Loc Code

ST066

9

68505

9

NAS1149DN832J

Purchased

No

110

Each

2,018.000

4

4



WASHER

Location

Loc Qty

Loc Code

ST297

2018

117316

1018

117887

1000

MS21042L08

Purchased

No

110

Each

378.0000

4

4



Nut

Location

Loc Qty

Loc Code

ST300

378

117441

3

117601

200

117677

25

117739

150

Tuesday, July 05, 2011 7:28:32 AM

Shop Packet Print

Page 3

Picklist Print

Tuesday, July 05, 2011 7:28:32 AM

Page 4

Work Order ID: 71478

Parent Item: D130-780-042

Parent Item Name: Spacepod, RH

Start Date: 7/5/2011

Required Date: 7/15/2011

Start Qty: 1.00

Required Qty: 1.00

D3815-041

Manufactured No

160

Each

20.0000

2

2

Web Assembly

Location

Loc Qty

Loc Code

ST203

20

53469

10

56562

10

D3837-1

Manufactured No

160

Each

12.0000

1

Decal

Location

Loc Qty

Loc Code

ST087

12

46231

1

56382

11

D3798-042

Manufactured No

160

Each

0.0000

1

Spacepod Floor

D3547-1

Manufactured No

160

Each

14.0000

1

Bracket

Location

Loc Qty

Loc Code

ST066

14

67604

14

D3550-1

Manufactured No

160

Each

21.0000

1

Strut

Location

Loc Qty

Loc Code

ST271

21

66019

9

69040

12

Tuesday, July 05, 2011 7:28:33 AM

Shop Packet Print

Page 4

Picklist Print

Tuesday, July 05, 2011 7:28:33 AM

Page 5

Work Order ID: 71478

Parent Item: D130-780-042

Parent Item Name: Spacepod, RH

Start Date: 7/5/2011

Required Date: 7/15/2011

Start Qty: 1.00

Required Qty: 1.00

D3554-7

 Ball Stud

Manufactured No 160 Each 20.0000

 1

Location	Loc Qty	Loc Code
ST067	20	
65123	9	
69496	11	


D3015-3

 Locknut

Manufactured No 160 Each 176.0000

 1


Location	Loc Qty	Loc Code
ST030	176	
66114	127	
67536	49	

AN3-3A

 Bolt

Purchased No 160 Each 387.0000

 4

Location	Loc Qty	Loc Code
ST350	387	
116924	12	
117619	75	
117795	300	

AN3-6A

 Bolt

Purchased No 160 Each 319.0000

 4

Location	Loc Qty	Loc Code
ST351	319	
116704	19	
117441	300	

Tuesday, July 05, 2011 7:28:33 AM

Shop Packet Print

Page 5

Picklist Print

Tuesday, July 05, 2011 7:28:33 AM

Page 6

Work Order ID: 71478

Parent Item: D130-780-042

Parent Item Name: Spacepod, RH

Start Date: 7/5/2011

Required Date: 7/15/2011

Start Qty: 1.00

Required Qty: 1.00

AN3-10A

Purchased

No

160

Each

168.0000

2

2

Bolt

Location

Loc Qty

Loc Code

ST351

168

117313

34

117795

134

AN5-5A

Purchased

No

160

Each

72.0000

1

1

Bolt

Location

Loc Qty

Loc Code

ST337

72

110865

72

AN525-10R7

Purchased

No

160

Each

242.0000

38

38

Screw

Location

Loc Qty

Loc Code

ST325

242

115016

1

115371

141

116737

100

MS24694-S67

Purchased

No

160

Each

205.0000

7

7

Screw

Location

Loc Qty

Loc Code

ST289A

205

106166

5

115016

200

Tuesday, July 05, 2011 7:28:33 AM

Shop Packet Print

Page 6

Picklist Print

Tuesday, July 05, 2011 7:28:33 AM

Page 7

Work Order ID: 71478

Parent Item: D130-780-042

Parent Item Name: Spacepod, RH

Start Date: 7/5/2011

Required Date: 7/15/2011

Start Qty: 1.00

Required Qty: 1.00

AN526C832R14 Purchased

No

160

Each

518.0000

8

8



Screw

Location

Loc Qty

Loc Code

ST327

518

104916

518

MS24694-S69

Purchased

No

160

Each

75.0000

1



Screw

Location

Loc Qty

Loc Code

ST289A

75

112492

75

A3235-020-935

Purchased

No

110

Each

366.0000

8

8



Washer - Countersunk

Location

Loc Qty

Loc Code

ST281

366

106150

366

NAS1149D0363J *

Purchased

No

160

Each

3,608.000

14

14



Washer

Location

Loc Qty

Loc Code

ST298

3608

117291

608

117505

500

117601

500

118077

2000

Tuesday, July 05, 2011 7:28:33 AM

Shop Packet Print

Page 7

Picklist Print

Tuesday, July 05, 2011 7:28:33 AM

Page 8

Work Order ID: 71478

Parent Item: D130-780-042

Parent Item Name: Spacepod, RH



Start Date: 7/5/2011

Required Date: 7/15/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0332J Purchased

No

160

Each

2,243.000

16

16



Washer

Location

Loc Qty

Loc Code

ST297

2000

117087

2000

ST298

243

105793

12

117291

84

118078

147

NAS1149D0563J Purchased

No

160

Each

4,939.000

3



Washer

Location

Loc Qty

Loc Code

ST298

4939

117291

6

117591

5

118206

4928

MS21042L3 Purchased

No

160

Each

1,905.000

22



Nut

Location

Loc Qty

Loc Code

ST300

1905

116549

211

117441

800

117601

400

117885

494

Tuesday, July 05, 2011 7:28:33 AM

Shop Packet Print

Page 8

Picklist Print

Tuesday, July 05, 2011 7:28:33 AM

Page 9

Work Order ID: 71478

Parent Item: D130-780-042

Parent Item Name: Spacepod, RH

Start Date: 7/5/2011

Required Date: 7/15/2011

Start Qty: 1.00

Required Qty: 1.00

MS21042L5

Purchased

No

160

Each

1,443.000

1



Nut

Location

Loc Qty

Loc Code

ST300

1443

116105

5

116548

240

117441

498

117591

100

117611

100

118179

500

AKS4-1032-130

AKS4-1032-130

Purchased

No

160

Each

0.0000

10



Inserts

D130-780-013

Manufactured

No

160

Each

1.0000

1



Switch Relocation

Location

Loc Qty

Loc Code

FG122

1

53905

1

Tuesday, July 05, 2011 7:28:33 AM

Shop Packet Print

Page 9

GENERAL NOTES:

1) MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")
18 oz ROVING "E" GLASS (18 oz CLOTH)
OWENS CORNING MILLED FIBERS, "E" GLASS
3M K20 GLASS BUBBLES

FOAM: A500 CORE CELL
OR DIVINYCELL
OR AIREX
OR KLEGECELL
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

1. MOLD SCHEDULE:

PART	LAYUP	TRIM AND DRILL
D3188-1M/-1/-5	DT8003	DT8501
D3188-2M/-2/-6	DT8004	DT8502
D3188-3M/-3/-7	DT8500	DT8501

2) FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S.
APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

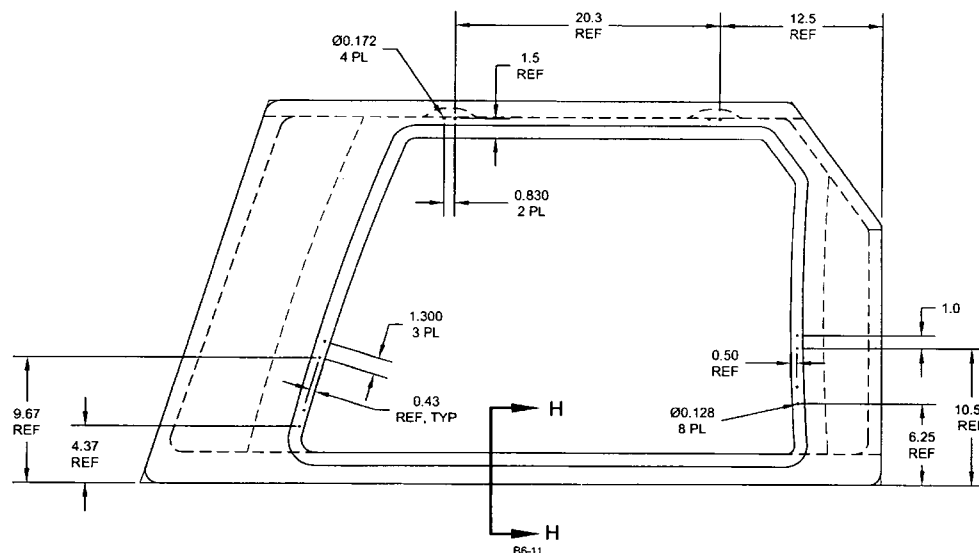
7) WEIGHT: D3188-1 = N/A
D3188-2 = N/A
D3188-3 = N/A
D3188-5 = N/A
D3188-6 = N/A
D3188-7 = N/A

8) REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING

9) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING

RELEASED
2009-10-20
MP

F	REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENTS STANDARDS; ADD CHAMFER IN SECTIONS A-A (ZN C7-10) & H-H (ZN B7-11)	RF	09.07.13
E	ADD HYSOL FIBER OPTION ON SHEET 11	CB	07.04.02
D	UPDATE DIMENSIONS	LE	07.02.22
C	REMOVED D0600-XXX LABELS	LE	06.12.13
B	UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/-2M/-3M/-5/-6/-7	CB	06.10.06
A	NEW ISSUE	CP	03.04.03
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D3188	SHEET 1 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SPACEPOD BODY	NTS
DATE	09.07.13	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	







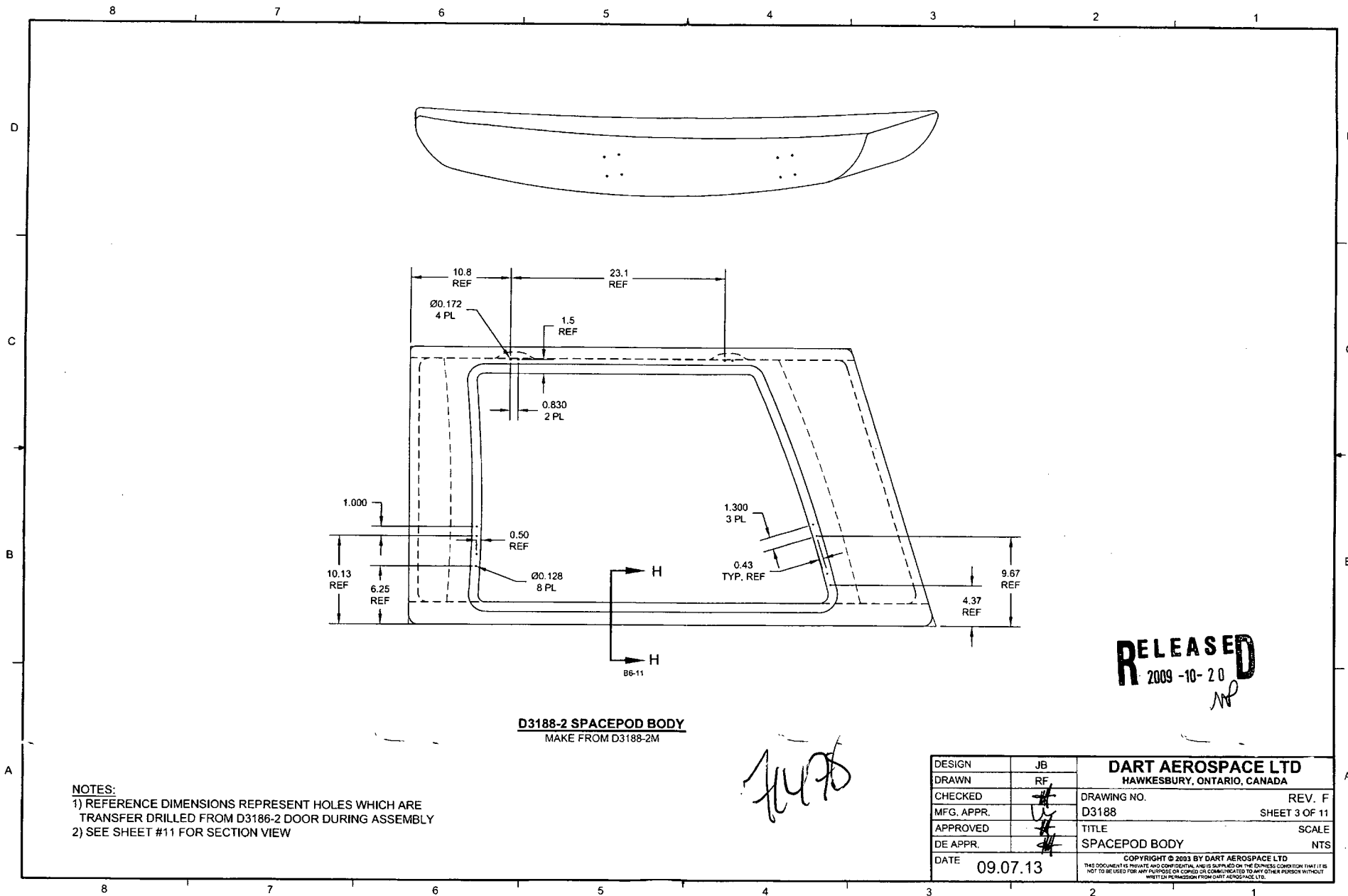
RELEASED
2009-10-20
MP

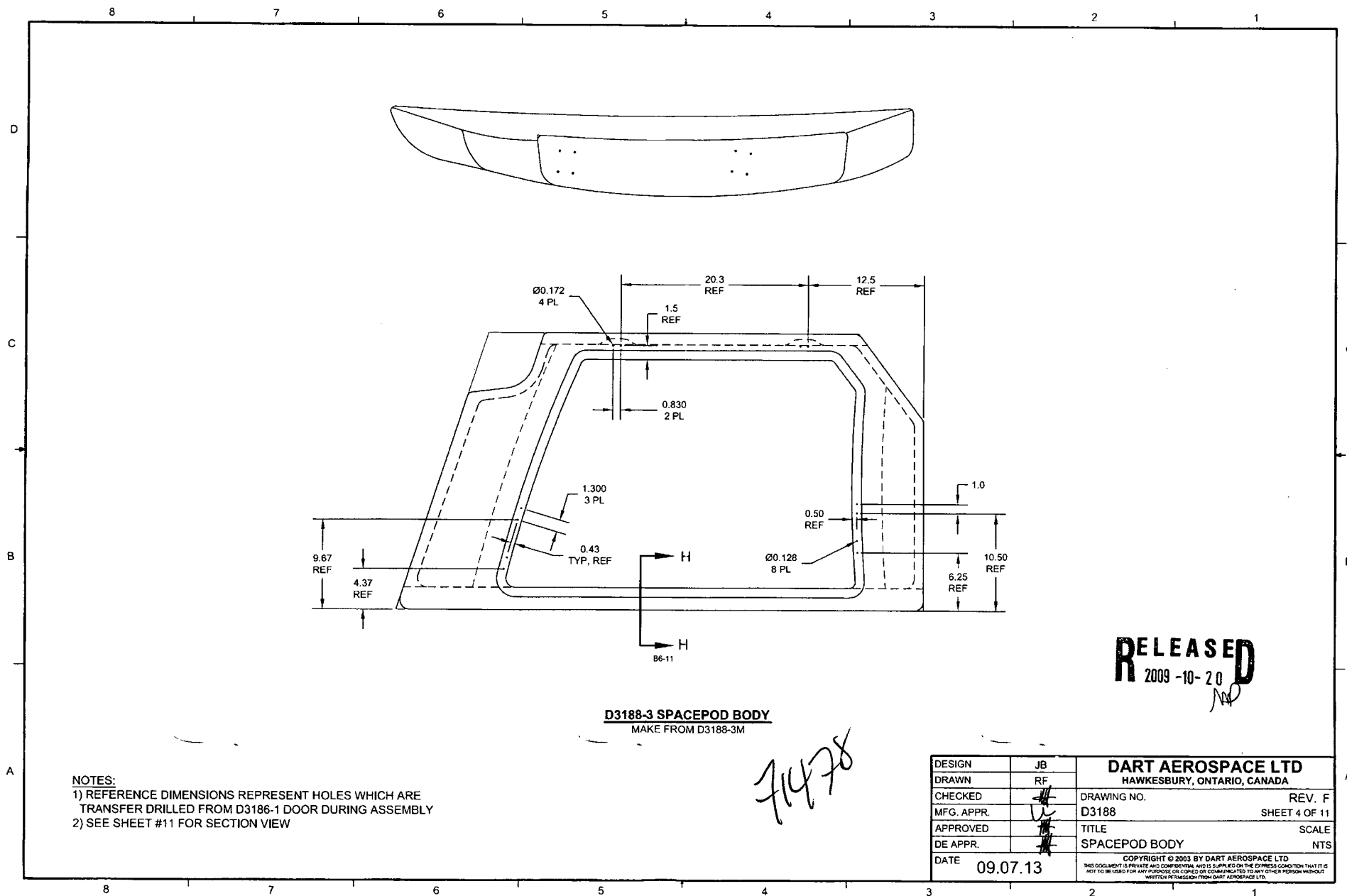
D3188-1 SPACEPOD BODY
MAKE FROM D3188-1M

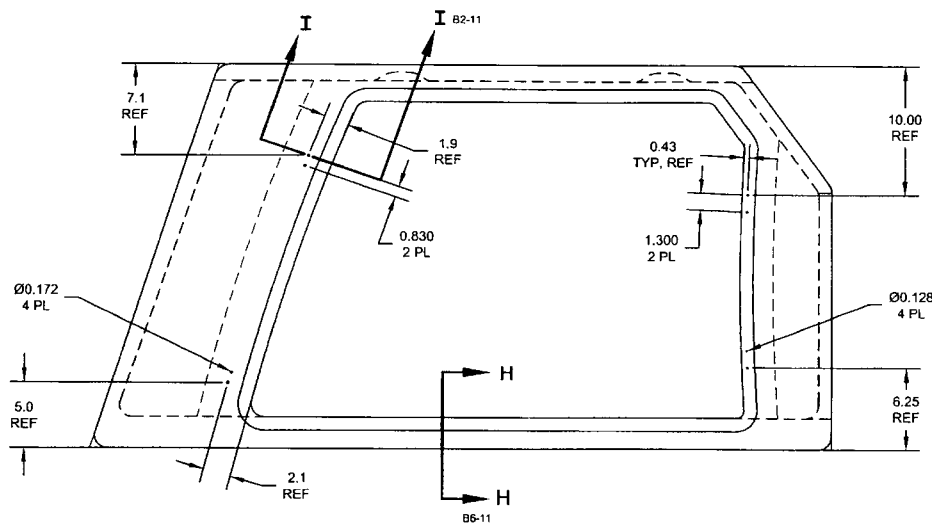
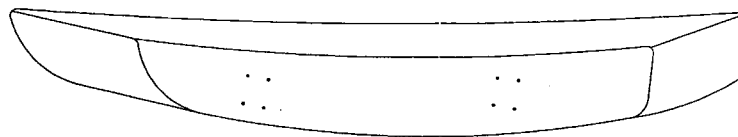
NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3188	SHEET 2 OF 11
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD BODY	NTS
DATE	09.07.13	COPYRIGHT © 2003 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPILED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			











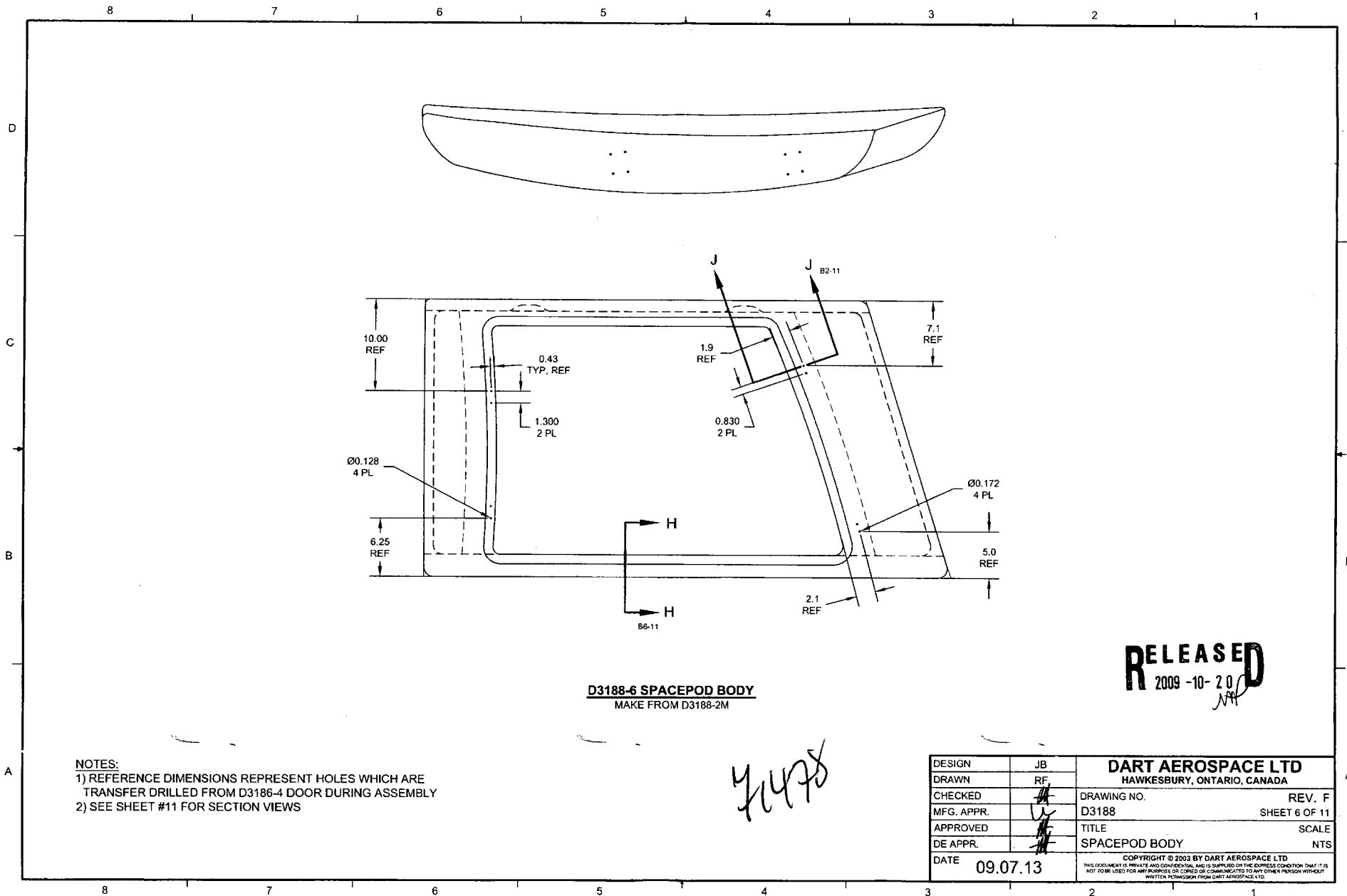
D3188-5 SPACEPOD BODY
MAKE FROM D3188-1M

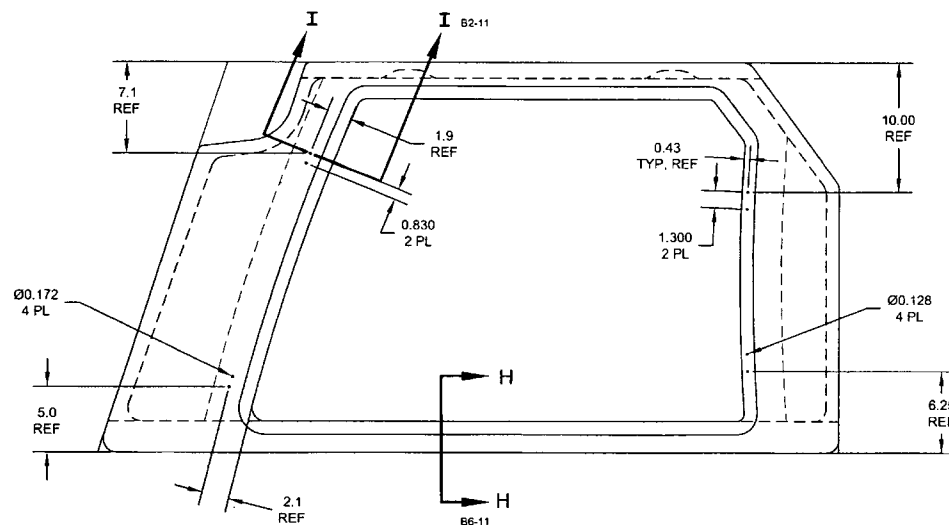
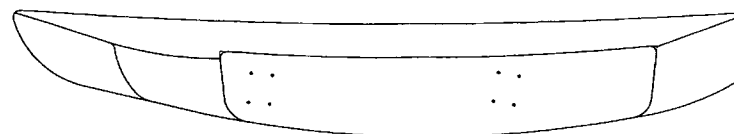
RELEASED
2009-10-20

NOTES:
1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE
TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
2) SEE SHEET #11 FOR SECTION VIEWS

Handwritten signature/initials

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3188	SHEET 5 OF 11
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD BODY	NTS
DATE	09.07.13	COPYRIGHT © 2003 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			





D3188-7 SPACEPOD BODY
MAKE FROM D3188-3M

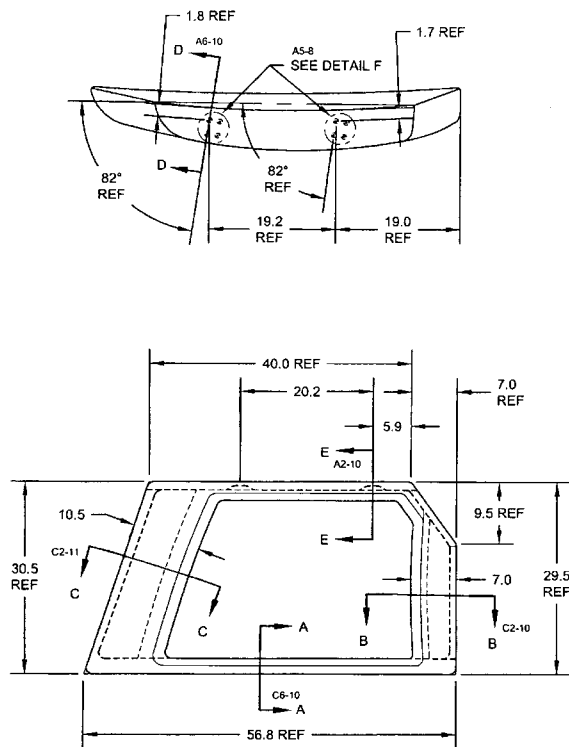
RELEASED
2009-10-20
NT

NOTE:

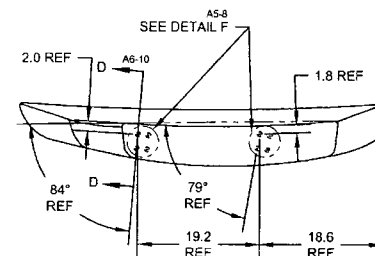
- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3188-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

Handwritten signature/initials

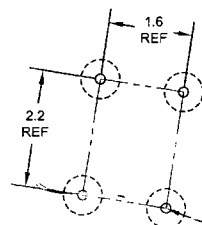
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. F
MFG. APPR.	RF	D3188	SHEET 7 OF 11
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	SPACEPOD BODY	NTS
DATE	09.07.13	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D3188-1M SPACEPOD BODY



D3188-3M SPACEPOD BODY



DETAIL F

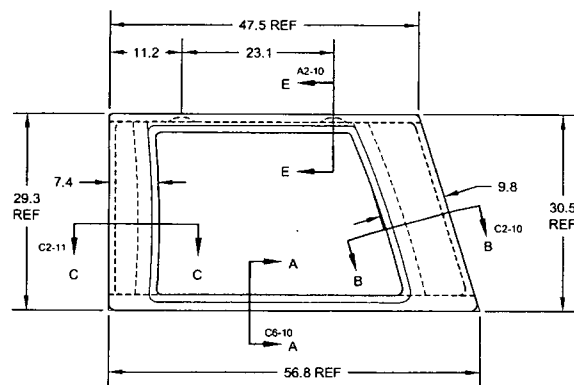
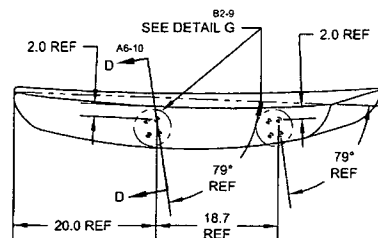
INSTALL
D2213 SPACER
8 PL
SEE SECTION D-D
A5-10

RELEASED
2009-10-23

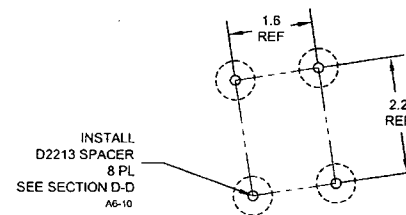
D3188-1M/-3M NOTES:

- 1) REFERENCE DIMENSIONS ARE FROM DT8003/DT8500 AND DT8501.
- 2) SEE SHEET #10 FOR SECTION VIEWS.

DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. F
MFG. APPR.		D3188	SHEET 8 OF 11
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD BODY	NTS
DATE	09.07.13	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D3188-2M SPACEPOD BODY



DETAIL G D6-9

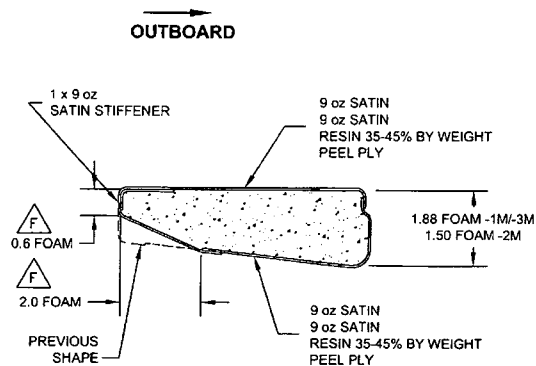
RELEASED
2009-10-20

D3188-2M NOTES:

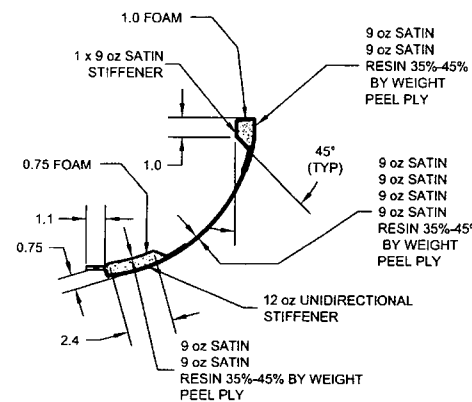
- 1) REFERENCE DIMENSIONS ARE FROM DT8004 AND DT8502.
- 2) SEE SHEET #10 FOR SECTION VIEWS.

71478

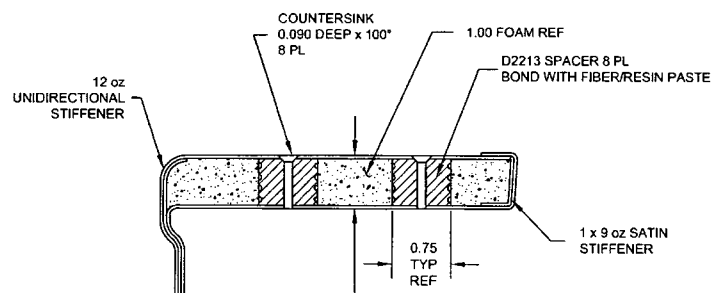
DESIGN	JB	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. F
MFG. APPR.	RF	D3188	SHEET 9 OF 11
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	SPACEPOD BODY	NTS
DATE	09.07.13	<small>COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



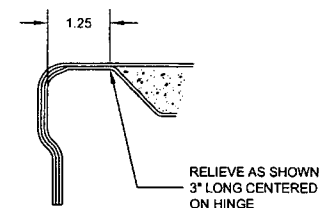
SECTION A-A
TYPICAL FLOOR SECTION
B7-8
B3-8
B6-9



SECTION B-B
SECTION C-C OPPOSITE
B6-8
B8-8
B4-8
B2-8
B7-9
B5-9



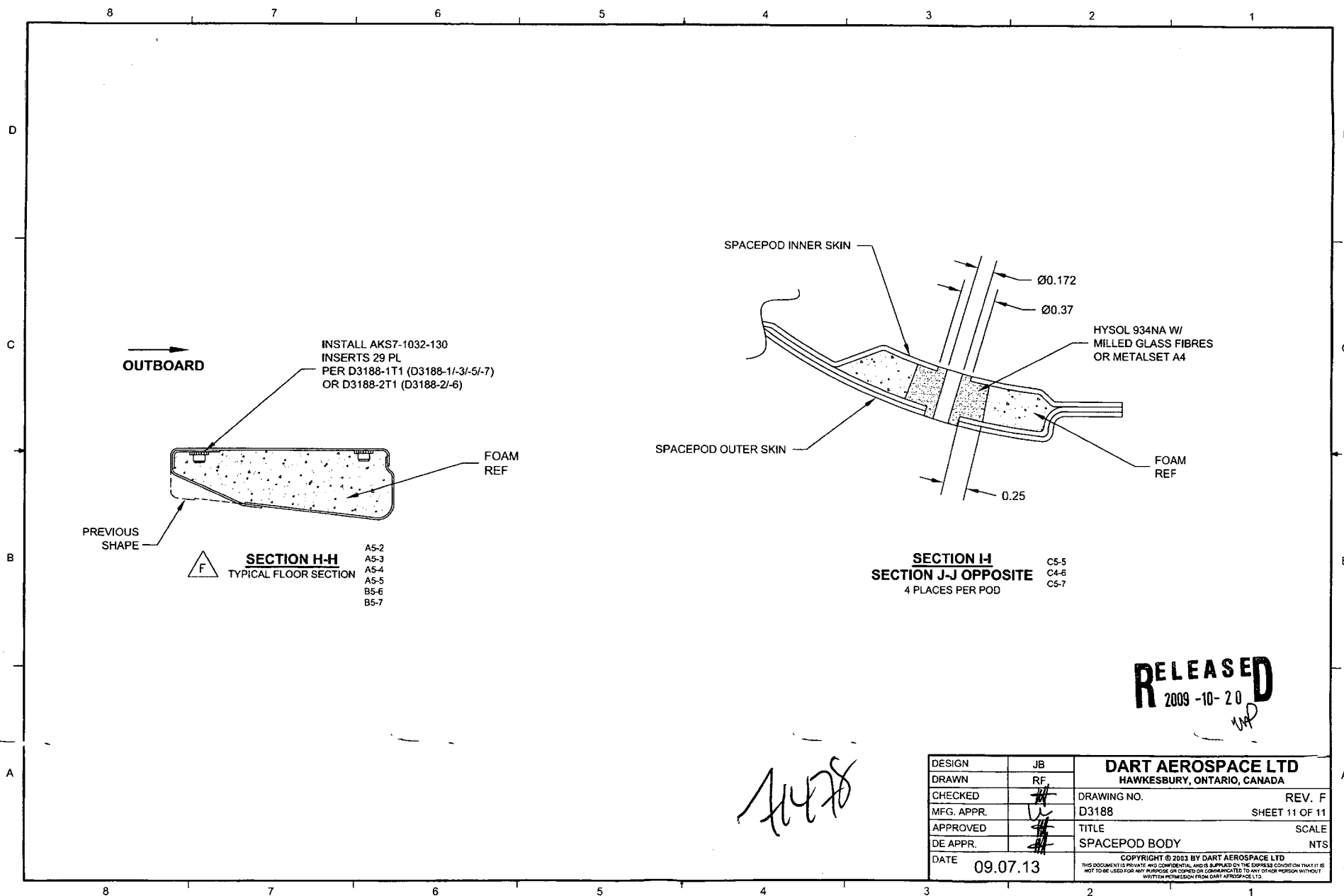
SECTION D-D
TYPICAL ROOF SECTION IS SIMILAR
BUT WITHOUT INSERTS
D3-8
D7-8
D6-9



SECTION E-E
2 PLACES PER POD
C2-8
C7-8
B6-9

RELEASED
2009-10-27

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. F
MFG. APPR.	RF	D3188	SHEET 10 OF 11
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	SPACEPOD BODY	NTS
DATE	09.07.13	COPYRIGHT © 2003 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD			



5.0 PARTS LIST

-041	-042	-043	-044	-011	-013	-015	Part Number	Description
X							D130-780-041	SPACEPOD™ LH, EC 130 B4
	X						D130-780-042	SPACEPOD™ RH, EC 130 B4
1		X					D130-780-043	DOOR ASSEMBLY, LH
	1		X				D130-780-044	DOOR ASSEMBLY, RH
1				X			D130-780-011	LH SLIDING DOOR HINGE KIT
1	1				X		D130-780-013	SWITCH RELOCATION KIT
				1		X	D130-780-015	CLOSEOUT KIT
2	2						D3815-041	WEB ASSEMBLY
3	3						D3815-5	PACKER
		1	1				D2589	KEYS, KEY CHAIN
1	1						D3837-1	DECAL
1	1						D3015-3	LOCK NUT
		1					D3186-3	SPACEPOD™ DOOR, LH
			1				D3186-4	SPACEPOD™ DOOR, RH
1							D3798-041	FLOOR
	1						D3798-042	FLOOR
1							D3188-5	SPACEPOD™ BODY
	1						D3188-6	SPACEPOD™ BODY
1	1						D3547-1	BRACKET
1	1						D3550-1	STRUT
		1	1				D3552-7	GAS SPRING
1	1						D3554-7	BALL STUD
4	4						AN3-3A	BOLT
4	4						AN3-6A	BOLT
2	2						AN3-10A	BOLT
1	1						AN5-5A	BOLT
38	38						AN525-10R7	SCREW
8	8						AN526C832R14	SCREW
6	6						MS24694S54	SCREW
7	7						MS24694S67	SCREW
1	1						MS24694S69	SCREW
		2	2				MS27039-0811	SCREW
8	8						A3235-020-935	WASHER
14	14						NAS1149D0363J	WASHER
16	16						NAS1149D0332J	WASHER
		4	4				NAS1149DN832J	WASHER
3	3						NAS1149D0563J	WASHER
		2	2				NAS1515H3	NYLON WASHER
		2	2				MS21042L08	NUT
22	22						MS21042L3	NUT (or MS21042-3)
1	1						MS21042L5	NUT
10	10						AKS7-1032-130	INSERT
28**	28**						AKS7-1032-130	INSERT
10	10						MS21059L3	NUTPLATE

© COPYRIGHT © 2008 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: B

Date: 09.06.11

-041	-042	-043	-044	-011	-013	-015	Part Number	Description
					2		D3819-1	MALE SPADE CONNECTOR
					2		D3597-1	FEMALE SPADE CONNECTOR
					1		D3598-2-096	EXPANDABLE SLEEVE
					24		D3599-1	TIE-WRAP
					24		D3600-1	TIE-WRAP MOUNT
					24 FT		M22759/41-22-9	WIRE
		1*	1*				D2464-1250	NEOPRENE SEAL
1**		1*					D3837-3	DECAL
	1**		1*				D3837-4	DECAL
		2*	2*				D2586	LATCH
		2*	2*				D2585	MOUNTING CHANNEL
		2*	2*				D2621	LATCH PLATE
		2*	2*				MS27039-1-15	SCREW
		2*	2*				NAS1149D0363J	WASHER
		2*	2*				MS21042L3	NUT (or MS21042-3)
		1*	1*				D2857-1	HINGE BRACKET
		1*	1*				D2857-2	HINGE BRACKET
		2*	2*				D2228	BACKING PLATE
		8*	8*				AN526C832R10	SCREW
		8*	8*				NAS1149DN832J	WASHER
		8*	8*				MS21042L08	NUT
		1*	1*				D3557-1	BRACKET
		2*	2*				D2228	BACKING PLATE
		1*	1*				D3554-7	BALL STUD
		1*	1*				NAS1149D0563J	WASHER
		1*	1*				D3015-3	LOCK NUT
		2*	2*				AN526C832R14	SCREW
		2*	2*				AN526C832R10	SCREW
		4*	4*				NAS1149DN832J	WASHER
		4*	4*				MS21042L08	NUT
2**	2**						D2237	STRIKER PLATE
4**	4**						MS20426AD4-5	RIVET
2**	2**						D3538-1	HINGE BRACKET
2**	2**						D2179	HINGE BRACKET PLATE
4**	4**						AN526C832R24	SCREW
4**	4**						NAS1149DN832J	WASHER
4**	4**						MS21042L08	NUT
				1			D3813-041	HINGE ASSEMBLY, UPPER DOOR
				1			D3813-043	HINGE ASSEMBLY, LOWER DOOR
				2***			D3518-3	ROD END

• COPYRIGHT © 2008 BY DART AEROSPACE LTD. •

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: B

Date: 09.06.11

-041	-042	-043	-044	-011	-013	-015	Part Number	Description
				2***			NAS509-6	NUT
				1			D3814-1	HINGE, UPPER AIRFRAME
				1			D3814-3	HINGE, LOWER AIRFRAME
				2			D3816-1	SPACER
				4			D3816-3	SPACER
				1			D3817-041	ANCHOR PLATE
				2			AN3-5A	BOLT
				3			AN3-7A	BOLT
				2			AN310-4	CASTLE NUT
				2			AN4-17	BOLT
				2			AN970-4	WASHER
				5			MS21042L3	NUT
				2			MS24665-212	COTTER PIN
				3			MS24694S46	SCREW
				8			NAS1149D0363J	WASHER
				2			NAS1149D0463J	WASHER
				1			D3552-7	GAS SPRING
				2			D3622-1	BALL STUD
				1			D3820-1	DOOR SUPPORT
				2			MS21042L5	NUT
				2			NAS1149D0563J	WASHER
				1			D3892-1	SEAL
						1	D3983-1	OUTER CLOSEOUT
						1	D3983-3	INNER CLOSEOUT
						1	D3983-5	HINGE CLOSEOUT
						1	D3983-047	CLOSEOUT ATTACHMENT
						1	D3983-9	SPACER
						2	AN525-10R6	SCREW
						1	AN525-10R24	SCREW
						1	NAS1149D0363J	WASHER
						1	MS21042L3	NUT

* Pre-installed on D3186-3/-4 Spacepod™ Door

** Pre-installed on D3188-5/-6 Spacepod™

*** Pre-installed on D3813-041/-043 Hinge Assemblies

• COPYRIGHT © 2008 BY DART AEROSPACE LTD •

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: **B**

Date: 09.06.11